

**WE CLAIM:**

1. A method of making a refastenable garment with attached side panels, comprising:

a. providing a garment chassis web with a longitudinal axis in a machine direction and edges opposed in the cross machine direction;

b. providing a side panel having a first fastener disposed on the side panel, the first fastener disposed between a waist end edge and a leg end edge of the side panel;

c. overlaying the side panel on the garment chassis web and securing the side panel to the garment chassis web whereby the side panel lays substantially between the edges of the garment chassis web; and

d. providing a cooperating fastener disposed on the chassis, the cooperating fastener spaced from the first fastener along the longitudinal axis of the chassis web.

2. The method of making a refastenable garment with attached side panels and a longitudinal axis in the machine direction according to Claim 1, further comprising: making the side panel coterminous with the garment chassis web opposed edges.

3. The method of making a refastenable garment with attached side panels and a longitudinal axis in the machine direction according to Claim 1, further comprising: making the side panel extend beyond the garment chassis web opposed edges.

4. The method of making a refastenable garment with attached side panels and a longitudinal axis in the machine direction according to Claim 1, further comprising: making the side panel lay within the garment chassis web opposed edges.

5. The method of making a refastenable garment with attached side panels and a longitudinal axis in the machine direction according to Claim 1, further comprising: arranging a portion of the side panel with respect to at least one garment chassis web opposed edge in an arrangement of one or more physical relationships selected from the group including coterminous, making the side panel extend beyond the at least one garment chassis web opposed edge, and making the side panel lay within the at least one garment chassis web opposed edge.

6. The method of making a refastenable garment with attached side panels according to Claim 1, further comprising:

- a. the garment chassis web and the secured side panel together making a garment web having first and second surfaces;
- b. the first fastener extending from the first surface; and

c. the cooperating fastener extending from the second surface in an opposite direction from the first surface.

7. The method of making a refastenable garment with attached side panels according to Claim 1, further comprising: providing one of a through-cut or a line of weakness in the side panel web and the first fastener at a longitudinal axis of the first fastener to form first and second side panels each comprising a first fastener portion.

8. The method of making a refastenable garment according to Claim 1 further comprising: individuating a garment by through-cutting the garment web in the cross direction.

9. The method of making a refastenable garment according to Claim 1 further comprising: securing the first fastener to the side panel web, and the side panel web to the garment chassis web, by ultrasonic bonding and adhesive reinforcement.

10. The method of making a refastenable garment according to Claim 1, wherein the first fastener is one of a loop material or hook material.

11. The method of making a refastenable garment according to Claim 8, further comprising: folding the side panel in a position partly inboard of one chassis width edge so as to place at least a portion of the first fastener outboard of the one chassis width edge.

12. The method of making a refastenable garment according to Claim 11 further comprising: folding the garment chassis web at a transverse midline thereof to place the first and second fasteners in proximity to each other.

13. The method of making a refastenable garment according to Claim 12 further comprising: folding the outboard positioned side panel to place the first fastener and the cooperating fastener in fastening contact.

14. The method of making a refastenable garment according to Claim 1, wherein the side panel web is made from material having stretch in the transverse direction of the garment.

15. The method of making a refastenable garment according to Claim 1, wherein the side panel web leg end edge is not straight.

16. The method of making a refastenable garment according to Claim 14, wherein the side panel web leg end edge is sinusoidal.

17. A method of making a refastenable absorbent garment with attached side panels and a longitudinal axis in the machine direction, comprising:

a. providing an absorbent chassis web with a longitudinal axis in the machine direction and a width with edges separated in the cross machine direction, and having an outside surface;

b. providing a side panel web with a waist end edge and a leg end edge, providing a first fastener on a side panel web inside surface, the first fastener disposed between the waist end edge and the leg end edge;

c. providing a line of weakness in the side panel web and the first fastener at a longitudinal axis of the first fastener to create first and second side panels each having a first fastener portion;

d. aligning the first fastener on the longitudinal axis of the absorbent chassis web and securing the side panel web with the first fastener thereon to the absorbent chassis web proximal to the edges of the absorbent chassis web with the waist end edge and the leg end edge separated in the machine direction;

e. disposing a cooperating second fastener on the outside surface of the chassis, the second fastener spaced in the machine direction from the first fastener;

f. folding said side panels partly inboard of the chassis width edges so as to place the first fastener portions outboard of the chassis edges and facing away from the absorbent chassis;

g. individuating an absorbent garment by separating the absorbent chassis web with a cut across the absorbent chassis web in the cross direction;

h. folding the absorbent chassis at a transverse midline thereof to place the first and second fasteners in proximity; and

i. folding the side panel web to place the first and second fasteners in fastening contact.

18. The method of making a refastenable garment according to Claim 17, further comprising: securing the first fastener to the side panel web, and the side panel web to the chassis web, by ultrasonic bonding with adhesive reinforcement.

19. The method of making a refastenable garment according to Claim 17, wherein the side panel web is made from spunbond laminate.

20. The method of making a refastenable garment according to Claim 17, wherein the side panel web is made from material having stretch in the transverse direction of the garment.

21. The method of making a refastenable garment according to Claim 17, wherein the side panel web leg end edge is not straight.

22. The method of making a refastenable garment according to Claim 17, wherein the side panel web leg end edge is sinusoidal.

23. A method of making a refastenable absorbent garment with attached side panels, comprising:

a. providing an absorbent chassis web with a longitudinal axis in a machine direction and a width with edges separated in a cross machine direction;

b. providing a side panel web with a flat edge and a sinusoidal edge, the sinusoidal edge having troughs closer to the flat edge and crests farthest from the flat edge, and disposing a loop fastener on the side panel web, the loop fastener strip disposed between the flat edge and the sinusoidal edge at a trough in the sinusoidal edge;

c. securing the side panel web to the absorbent chassis web;

d. separating the side panel web with the loop fastener thereon at a longitudinal axis of the side panel web to create first and second side panels each with loop fasteners;

e. attaching cooperating hook fasteners to the absorbent chassis web on an outside surface of the absorbent chassis web, the hook fasteners spaced in the machine direction from the loop fasteners and proximal to the absorbent chassis width edges;

f. folding the first and second side panels partly inboard of the chassis width edges so as to place the loop fasteners outboard of the chassis edges;

g. individuating an absorbent garment by separating the absorbent chassis web with a cut across the absorbent chassis web in the cross direction;

h. folding the absorbent chassis at a transverse midline thereof to place the hook and loop fasteners in proximity; and

i. folding the outboard portions of the side panels to place the hook and loop fasteners in fastening contact.

24. The method of making a refastenable garment according to Claim 23, further comprising: securing a loop fastener strip to the side panel web, and the side panel web to the chassis web, by ultrasonic bonding with adhesive reinforcement.

25. The method of making a refastenable garment according to Claim 24, wherein the side panel web is made from spunbond laminate.

26. The method of making a refastenable garment according to Claim 24, wherein the side panel web is made from material having stretch in the transverse direction of the garment.



27. A refastenable garment with attached side panels, comprising:
- a. a garment chassis web having a longitudinal axis and a width having edges separated in the cross machine direction and further having outside and inside surfaces;
  - b. a side panel web with a waist end edge and a leg end edge, and with a first fastener disposed between the waist end edge and the leg end edge;
  - c. the side panel web and the first fastener separated between the waist end edge and the leg end edge to create first and second side panels;
  - d. the side panel web secured to the garment chassis web;
  - e. cooperating second fasteners disposed on the chassis on an outside surface thereof, the second fasteners spaced from the first fasteners in the longitudinal axis of the chassis web;
  - f. the side panel web being folded in a position partly inboard of one of the chassis width edges;
  - g. the garment chassis web folded at a transverse midline thereof to place the first and second fasteners in proximity; and
  - h. the side panel having a second fold to place the first fastener and the second fastener in fastening contact.